

Work Order ID 62855

Tuesday, October 12, 2010 11:43:19 AM



Page 1

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Lid Assembly				Stop	
Start Date:	10/12/2010	Start Qty: 1.00		Cust Item ID:		
Required Date:	10/22/2010	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	10-10-12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989								
	2- tack weld mesh on basket as per dwg D2989 using DT9445 jig								
	****cut cutouts with zip cut as per dwg D3832****								
	3- remove from jig and weld lable plate as per dwg D2989								
	A/R ER316 S.S. Rod Batch: 111585								
	4- JUST AUTOMATIC LID OPENER								
	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110	QC	0.00							
	Quality Control								

10-10-04
10/11/15

10-11-09

1 of

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

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Start Date: 10/12/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

(H)

10-11-15
For A
matt

1 BR 10-11-10

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	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to powder coating								
	2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989								
	1ST COAT:								
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								
	***** 2nd coat if necessary *****								
	2ND COAT:								
	START TIME:								
	OVEN TEMPERATURE:								
	FINISH TIME:								
131 	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
HandFinish	Memo	0.00							
Hand Finishing	Mask lid prior to spray paint black and wing walk as per dwg								
	A/R Spray paint black batch:								

1 DR 10-11-10

✓ Wing Walk as per dwg QSI005 4.4 Batch M115780 => gl 10/11/11

1 or

✓ Mask lid prior to spray paint black and wing walk as per dwg
A/R Spray paint black batch: M115193

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

EP 10/11/16 *Q*

141



Packaging

Packaging

Identify as per dwg & Stock Location: *C-A*

0.00

Memo

w/o 62848

0.00

EP 10/11/16

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CK 10/11/17

B/ 10-11-17
Q

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Picklist Print

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Page 1

Work Order ID: 62855



Parent Item: D2989-041



Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	14.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>61091</div> <div>61424</div> </div> <div> <div>Loc Qty</div> <div>14</div> <div>2</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2506 Label Plate		Manufactured	No			100	Each	7.0000	1	1			
<div> <div>Location</div> <div>WA</div> <div>61174</div> <div>61464</div> </div> <div> <div>Loc Qty</div> <div>7</div> <div>2</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2512-7 Rib		Manufactured	No			100	Each	7.0000	1	1			
<div> <div>Location</div> <div>WA</div> <div>60669</div> <div>62368</div> </div> <div> <div>Loc Qty</div> <div>7</div> <div>3</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

Cpl 10-11-04

362519 → (2)

Cpl 10-11-04

(1)

Cpl 10-11-04

(1)

W/O:		WORK ORDER CHANGES					
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Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2581

 Mounting Bracket

Manufactured No

100 Each

51.0000

2 2



Lpl 10-11-04

Location

Loc Qty

Loc Code

WA

51

60470

31

61953

20

2

D2989-13

 Rib

Manufactured No

100 Each

6.0000

2 2



Lpl 10-11-04

Location

Loc Qty

Loc Code

WA

6

61425

6

B63000 → 2

D2989-19

 Rib

Manufactured No

100 Each

6.0000

2 2



Lpl 10-11-04

Location

Loc Qty

Loc Code

WA

6

61427

6

B63001 → 2

D3832-3

 Mesh (Lid)

Manufactured No

100 Each

3.0000

1 1



Lpl 10-11-04

Location

Loc Qty

Loc Code

WA

3

61284

3

B62354 → 1

B62933 → 1

Tuesday, October 12, 2010 11:43:24 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 62855

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3833-3 Manufactured No

100

Each

13.0000

2

2



Mesh (Lid End)

Location

Loc Qty

Loc Code

WA

13

46308

1

61319

6

62384

6

D3836-041 Manufactured No

100

Each

3.0000

1



Rib Assembly (Basket Lid, LH)

Location

Loc Qty

Loc Code

WA

3

61429

3

D3836-042 Manufactured No

100

Each

3.0000

1

1



Rib Assembly (Basket Lid, RH)

Location

Loc Qty

Loc Code

WA

3

61431

3

D3852-041 Manufactured No

100

Each

3.0000

1

1



Rib Assembly

Location

Loc Qty

Loc Code

WA

3

61433

3



Rpl 10-11-04

Rpl 10-11-04

Rpl 10-11-04

Rpl 10-11-04

②

362936 → ①

362935 → ①

362990 → ①

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, October 12, 2010 11:43:24 AM

Page 4

Work Order ID: 62855



Parent Item: D2989-041



Parent Item Name: Basket Lid Assembly

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3852-042

Manufactured No

100

Each

3.0000

1

1



Rib Assembly



Location

Loc Qty

Loc Code

WA

3

61434

3

Cpl 10-11-04
B62989 → ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

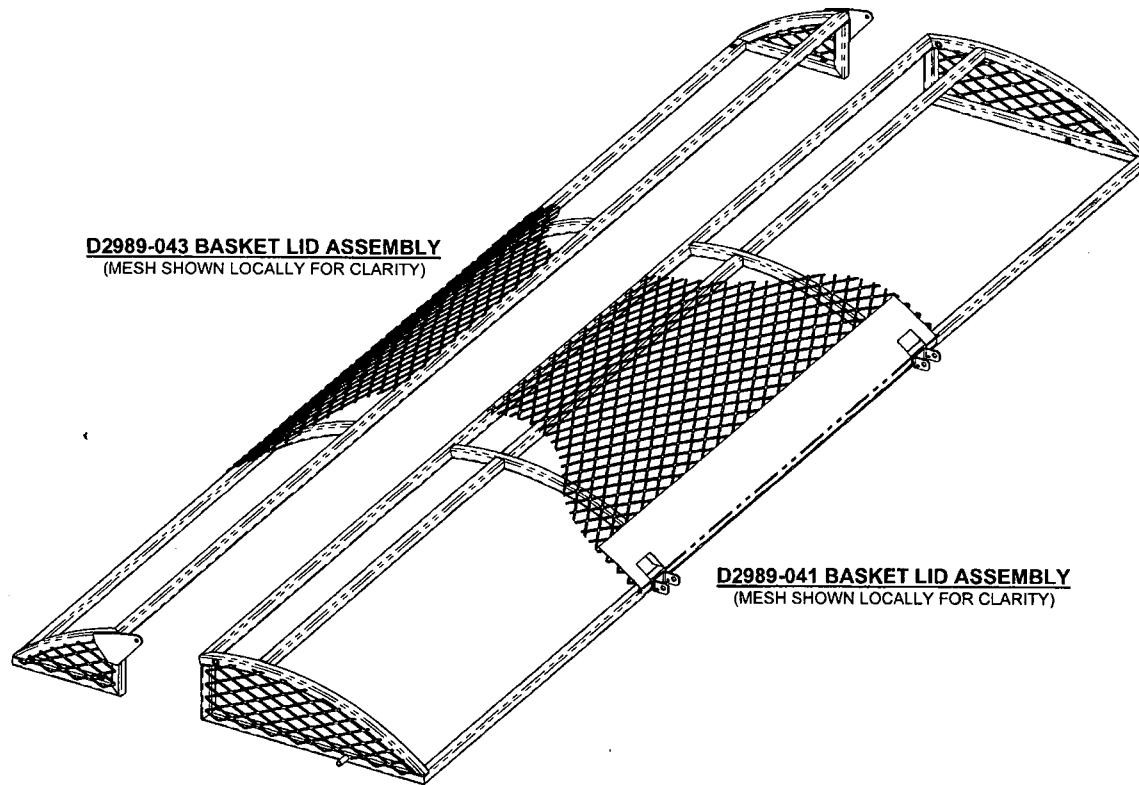
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
8/11/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

NO. 62865
3/10-10-12

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (2N D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

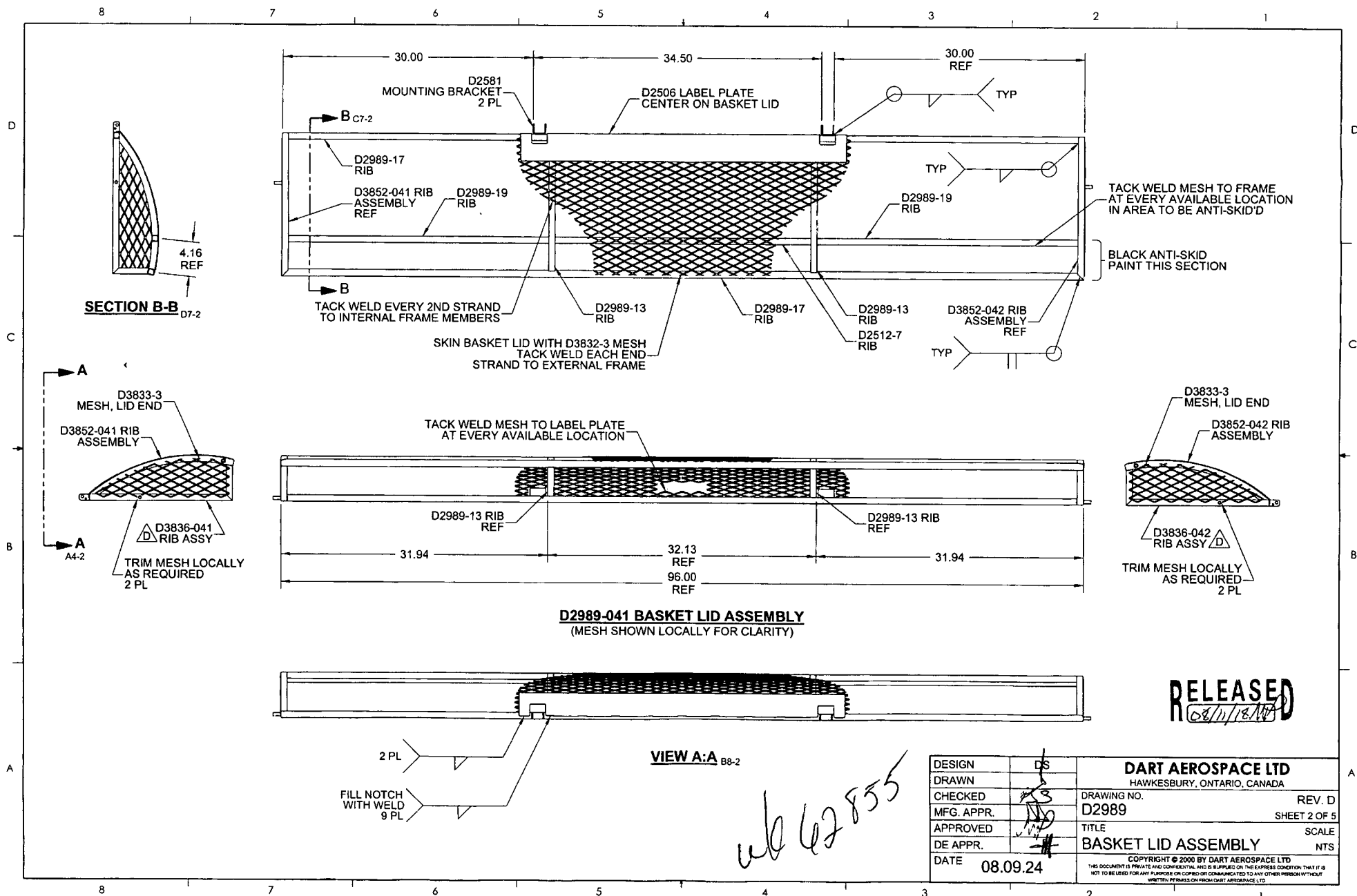
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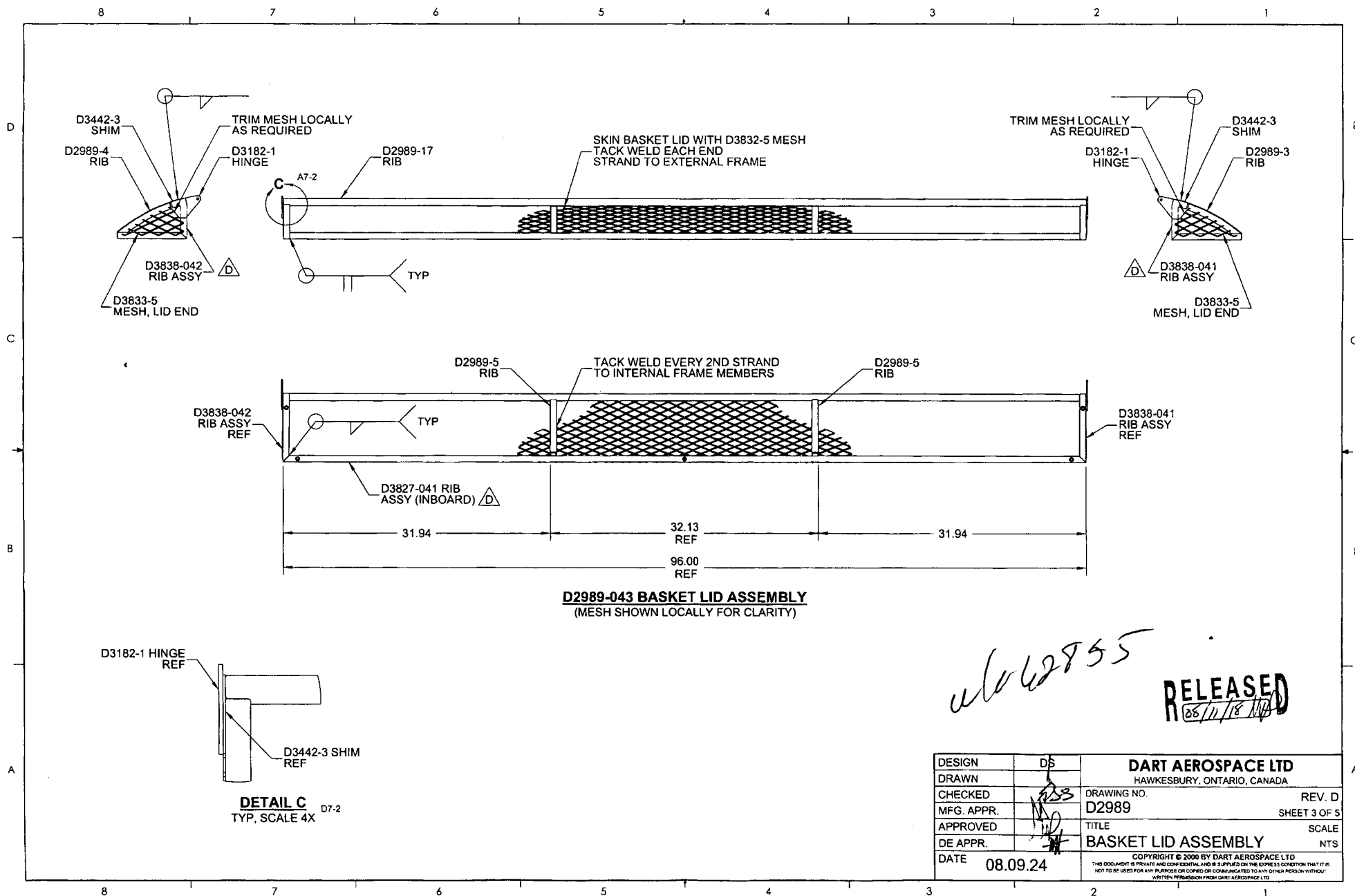
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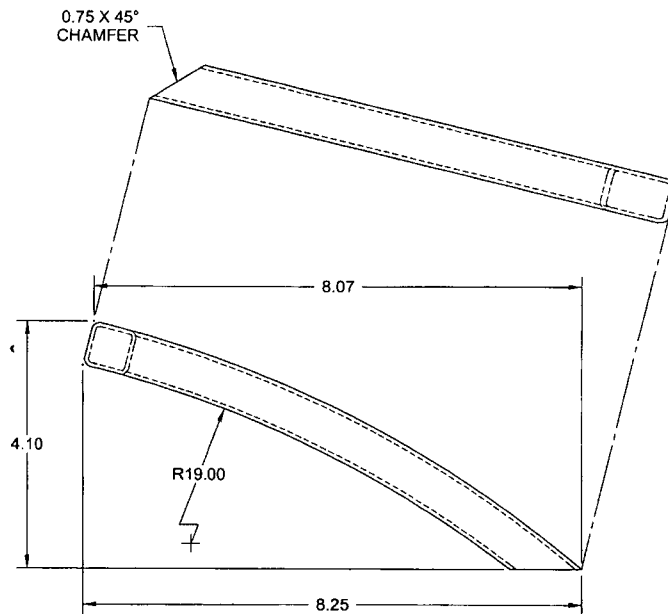
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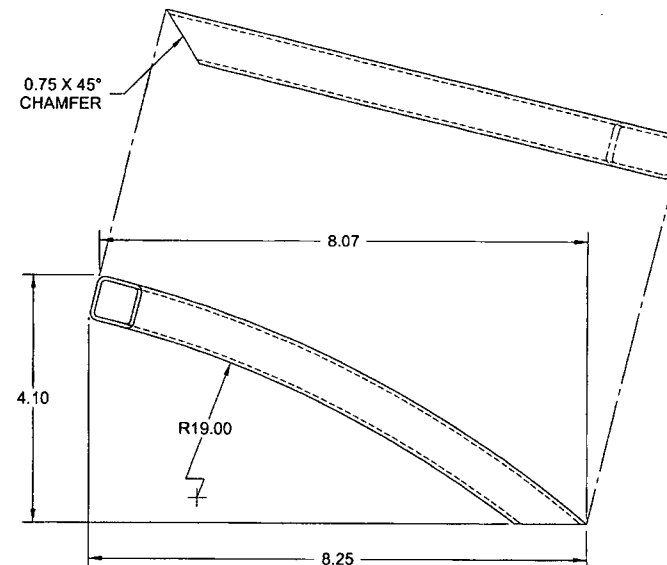
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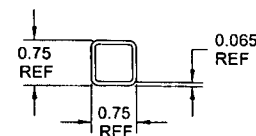
NOTE: Date & initial all entries



D2989-3 RIB



D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

RELEASED
08/11/18 NW

who 62855

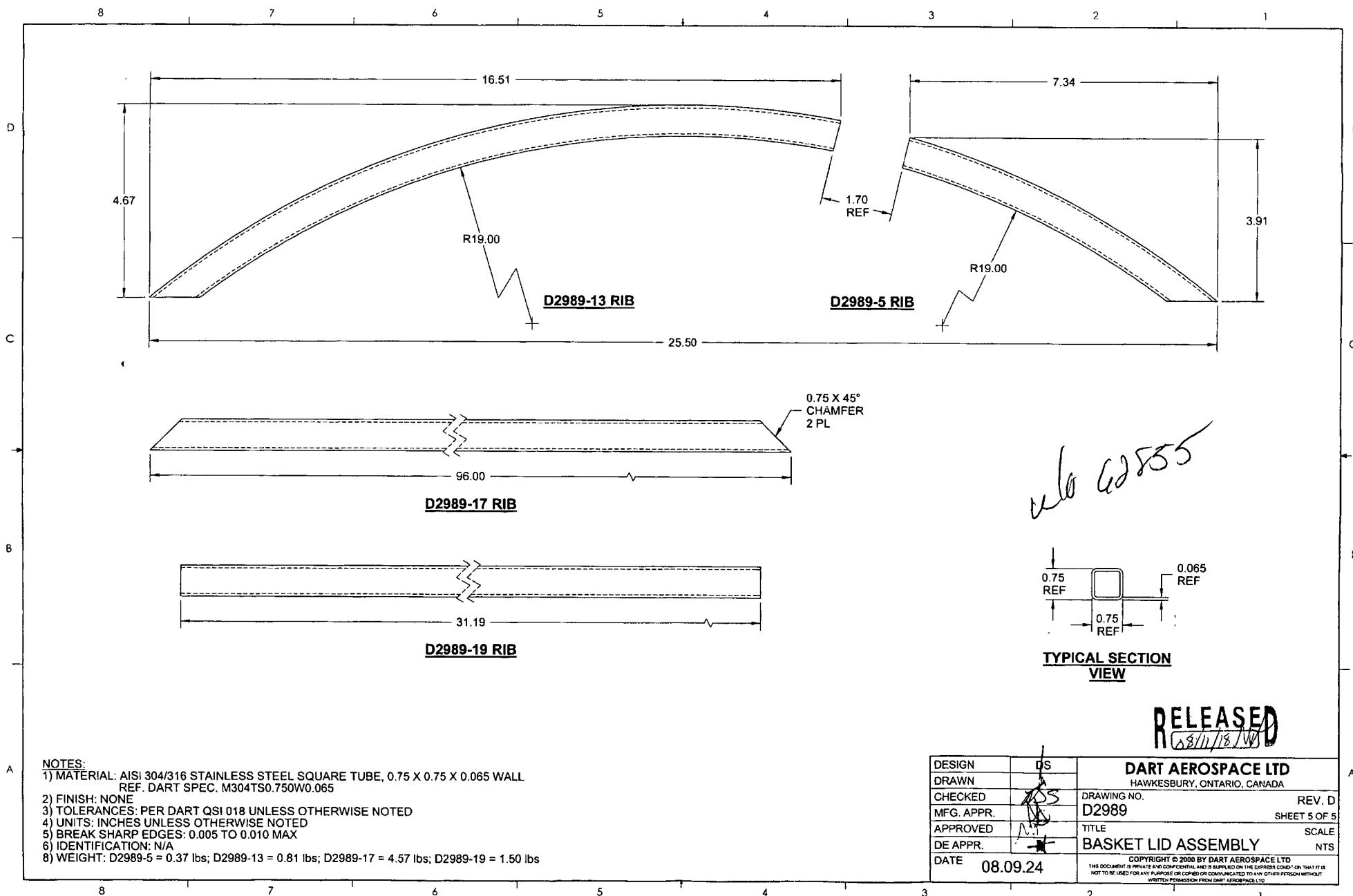
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WLB 62555

RELEASED
08/11/18/WJ

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 5 OF 5
APPROVED	<i>MT</i>	TITLE BASKET LID ASSEMBLY	SCALE NTS
DE APPR.	<i>JS</i>		
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries